

52

Date: Thursday, 11/29/2007 11:10:51 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HIGH AFT X-TUBE 412	
Job Number	36061		Part Number	D412664203	
Estimate Number	10559		Drawing Number	D412-664-243 REV D	
P.O. Number	:		Project Number	N/A	
This Issue	11/29/2007	S.O. No. :	Drawing Revision	D	
Prsht.Rev.	NC		Material	:	
First Issue	11/29/2007	Type : LANDING GEAR	Due Date	12/24/2007	Qty: 1 Um: Each
Previous Run	36060				
Written By	:				
Checked & Approved By	:				
Comment	Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Comments on Pick List JLM Est Rev:G 06.12.08 per ECN 886 EC Est Rev:H 07-04-30 As per Rev D JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL  Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006  J-F 07/11/29 ①
2.0	D6009129	Crosstube Material  Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube <u>332306</u> Check OD = 3.500"; ID = 2.250"  J-F 07/12/12 ①
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE  Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166 2-Turn first side as per Folio FA166  J-F 07/12/16 ①
4.0	QC1	INSPECT ALL DIM TO DIM SHEET  Comment: INSPECT ALL DIM TO DIM SHEET  J-F 07/12/16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HIGH AFT X-TUBE 412
Job Number: 36061		Part Number: D412664203
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	MORI SEIKI 	MORI SEIKI CNC LATHE LARGE 
Comment: MORI SEIKI CNC LATHE LARGE		
1-Turn second side as per Folio FA166		
2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.		
3- Remove sand and plugs		
4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243 Inside of Cuff(Donot engrave on outside of tube)		
6.0	QC1 	INSPECT ALL DIM TO DIM SHEET 
Comment: INSPECT ALL DIM TO DIM SHEET <i>J.F. 07/12/16 ①</i>		
7.0	QC8 	SECOND CHECK 
Comment: SECOND CHECK <i>8F 07/12/17 ①</i>		
8.0	LANDING GEAR 1 	LANDING GEAR RESOURCE 1 
Comment: LANDING GEAR RESOURCE 1 <i>AWM 07-12-18</i>		
1-Polish entire outside surface of crosstube		
9.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP <i>07/12/18 (X)</i>		
10.0	HAND FINISHING 	HAND FINISHING RESOURCE #1 <i>AWM 07-12-18</i> 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
11.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: Inspect work & Chemical conversion Coat <i>AC 07-12-27</i>		

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Process Sheet

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Job Number: 36061		Part Number: D412664203
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	BENDING	BENDING MACHINE
Comment: BENDING MACHINE		
Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010		EL 7-12-28
13.0	QC15	DIMENSIONAL CHECK OF X-TUBES
Comment: DIMENSIONAL CHECK OF X-TUBES		10-01-03 ①
14.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1		
1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551		SR
2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.		8-1-4
3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243		AWM 08-01-09
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		AWM 08-01-09
Chemical Conversion Coat as per QSI 005 4.1		
16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08/01/14 ①
17.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		08/01/14 ①
18.0	OUTSIDE SERV.10	OUTSIDE SERVICES -LG
Comment: Sub-Contracting OUTSIDE SERVICES		
Liquid Penetrant Inspection as per QSI 038Or		
Issue P/O: 5434 LPI as per ASTM 1417		
Level 2 Attach copy of NDT results to work order		C208/01/14 ①

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HIGH AFT X-TUBE 412
Job Number: 36061		Part Number: D412664203
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
19.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order.		<i>Pc 8/1/11 ①</i>
20.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: Inspect for damage & ensure results are as per Dwg D412-664-203		<i>8/1/11 ④</i>
21.0	SPRAY PAINTING 	SPRAY PAINTING 
Comment: SPRAY PAINTING 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2		<i>25 08-01-12</i>
22.0	QC14 	INSPECT SPRAY PAINT 
Comment: Inspect Spray Paint Wrap in plastic bag to protect from scratches		<i>8/1/11 ④</i>
23.0	D3595 	Rubber Cushion (per sq ft) <i>D3595063570 8/1/11 ④</i>
Comment: Qty.: 0.0492 sf(s)/Unit Total : 0.0492 sf(s) Rubber Cushion (per sq ft) .630" x5.70" x2pcs Batch: <i>33835</i>		<i>25 08-01-24</i>
24.0	D2856600 	Abrasion Strip 
Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s) Pick: Qty Part number Description Batch 2 D2856-600(Cut to 10.090") Abrasion Strip <i>25656</i>		<i>25 08-01-23</i>
25.0	D28961 	Support 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D2896-1 Support <i>30200</i>		<i>25 08-01-24</i>

W/O:		WORK ORDER CHANGES					
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Job Number: 36061		Part Number: D412664203		
Job Number: 				
Seq. #:	Machine Or Operation:	Description :		
26.0	D31891 	Chafing Shield 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)				
Pick:				
Qty	Part number	Description	Batch	
2	D3189-1	Chafing Shield	<u>35903</u>	<u>RT 08-01-23</u>
27.0	MS2192028 	Clamp(per MIL-DTL-8783C) 		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Pick:				
Qty	Part number	Description	Batch	
4	MS21920-28	Clamp	<u>104423</u>	<u>RT 08-01-23</u>
28.0	MS2192030 	clamp(per MIL-DTL-8783C) 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)				
clamp(per MIL-DTL-8783C)				
batch: <u>106810</u>		<u>RT 08-01-24</u>		
29.0	LANDING GEAR 1 	LANDING GEAR RESOURCE 1 		
Comment: LANDING GEAR RESOURCE 1				
Assemble as per Dwg D412-664-203				
1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs				
A/R	6398 Magnobond	Batch: <u>106 699</u>	<u>RT 08-01-24</u>	
Expiry Date: <u>08-11-01</u>				
2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.		<u>RT 08-01-28</u>		
30.0	QC5 	INSPECT WORK TO CURRENT STEP 		
Comment: INSPECT WORK TO CURRENT STEP		<u>106, 107, 30</u>		
31.0	PACKAGING 1 	PACKAGING RESOURCE #1 		
Comment: PACKAGING RESOURCE #1				
Pick Packing Kit				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Job Number: 36061		Part Number: D412664203
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
32.0	AN640A	Bolt 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt Batch: <u>M104517</u>		<u>10</u>
33.0	AN641A	Bolt 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt Batch: <u>M104427</u>		<u>11</u>
34.0	AN960JD616	Washer 
Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s) Washer Batch: <u>M105906</u>		<u>12</u>
35.0	MS21042L6	Nut 
Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Nut Batch: <u>M104379</u>		<u>13</u>
36.0	QC4	INSPECT 100% KITS FOR COMPLETENESS 
Comment: INSPECT 100% KITS FOR COMPLETENESS		<u>14</u>
37.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-664-203		<u>15</u>
*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date *****		
Time & date of packaging: <u>11/29 8/21</u>		
Location: _____ PPP Rev: <u>G</u> <u>8/21/08</u> <u>1x</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/06/04
 QA: N/C Closed: _____ Date: _____

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 36061

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/29/07

Job Completion



2008/10/04 ①

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36061
Description: Crosstube Assembly (412 High Aft)		Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

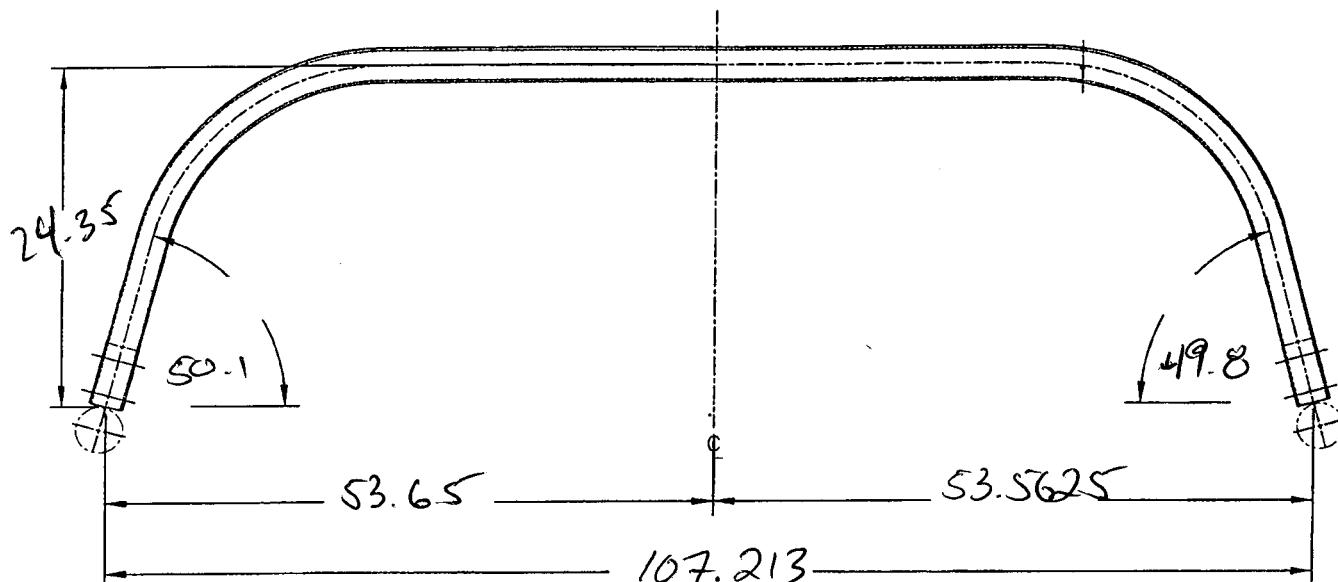
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.689"	✓		
	2.748	+0.005/-0.000	2.753"	✓		
	2.884	+0.005/-0.000	2.889"	✓		
	3.019	+0.005/-0.000	3.023"	✓		
	3.163	+0.005/-0.000	3.165"	✓		
	3.308	+0.005/-0.000	3.310"	✓		
	3.429	+0.005/-0.000	3.430"	✓		
	2.990	+0.005/-0.000	2.993"	✓		
	2.618	+0.005/-0.000	2.621"	✓		
	0.200	+/-0.010	.200"	✓		
	R0.063	+/-0.010	R0.063"	✓		
	R0.500	+/-0.010	R0.500"	✓		
	4.971	+/-0.030	4.965"	✓		
SIDE B	2.684	+0.005/-0.000	2.688"	✓		
	2.748	+0.005/-0.000	2.753"	✓		
	2.884	+0.005/-0.000	2.889"	✓		
	3.019	+0.005/-0.000	3.023"	✓		
	3.163	+0.005/-0.000	3.165"	✓		
	3.308	+0.005/-0.000	3.311"	✓		
	3.429	+0.005/-0.000	3.431"	✓		
	2.990	+0.005/-0.000	2.992"	✓		
	2.618	+0.005/-0.000	2.621"	✓		
	0.200	+/-0.010	.200"	✓		
	R0.063	+/-0.010	R0.063"	✓		
	R0.500	+/-0.010	R0.500"	✓		
	4.971	+/-0.030	4.969"	✓		
	124.09	+/-0.020	124.070"	✓		

Measured by:	J.F.	Audited by:	J.F.	Prototype Approval:	N/A
Date:	07/12/16	Date:	07/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	

DART AEROSPACE LTD	Work Order:	36061
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243	Rev: D	Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	<i>0801-03</i>
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>JM</i>
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	<i>JLM</i>

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>QP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE NTS
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

RELEASED

07.04.24 *[Signature]*

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

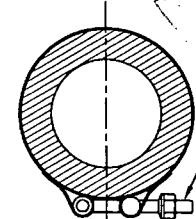
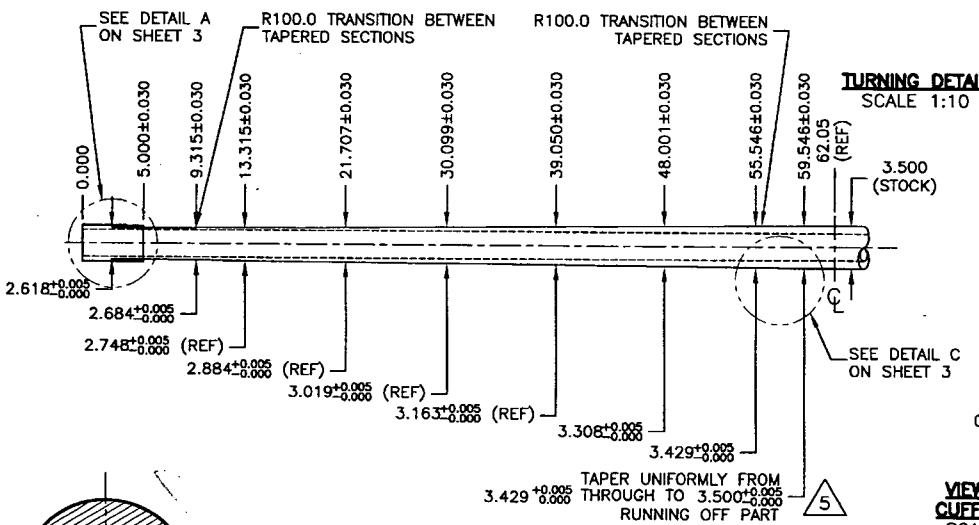
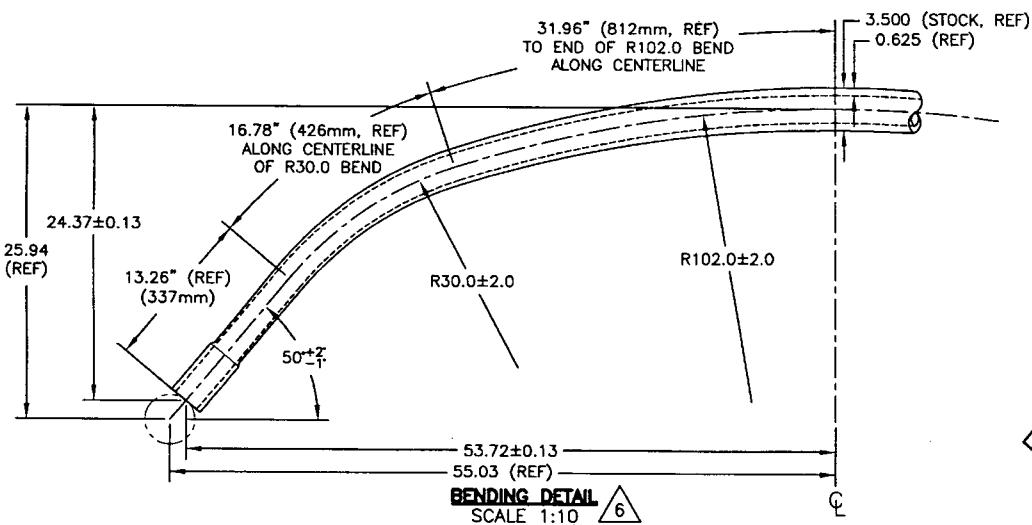
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO $0.005"$ MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A $0.03"$ TO $0.06"$ THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

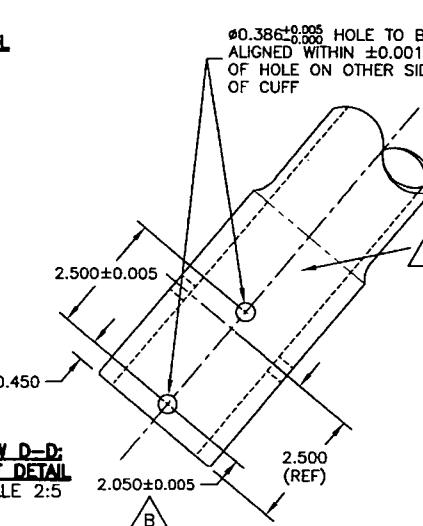
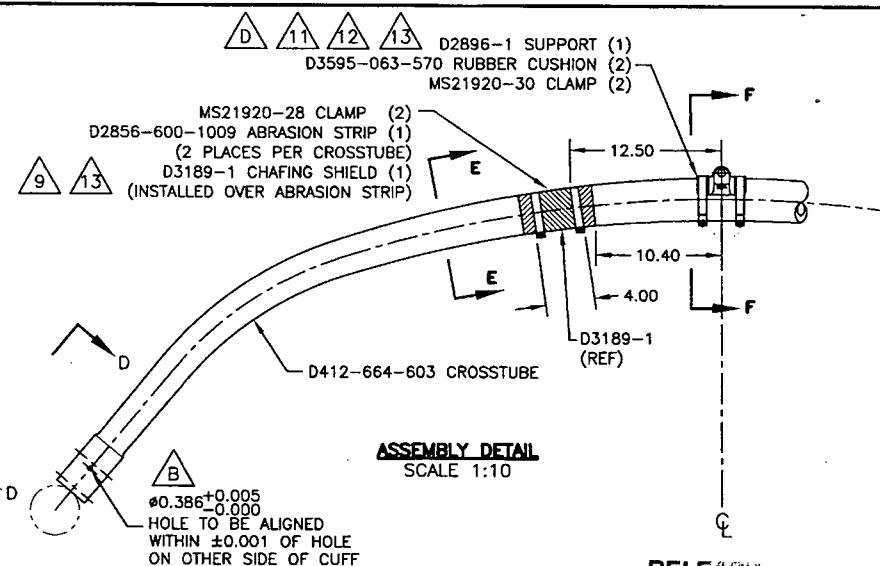
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3606

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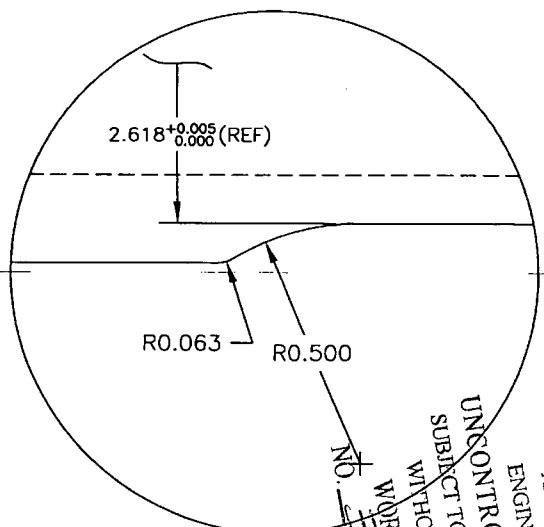
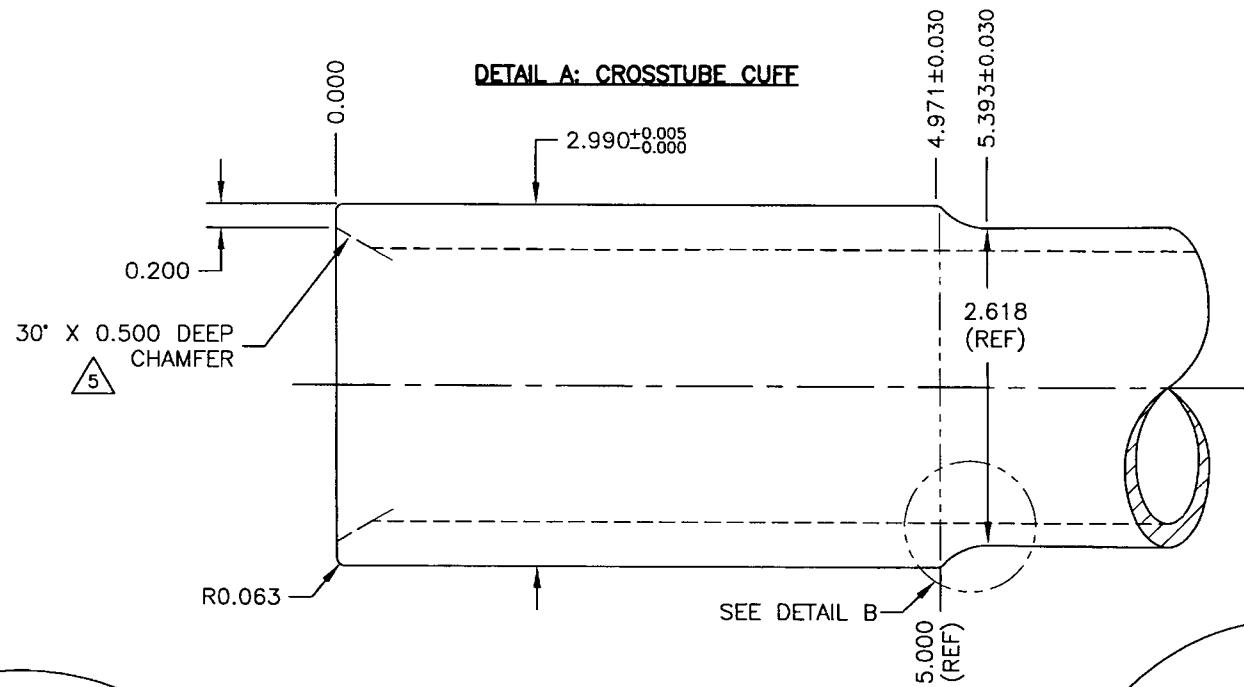


WORK ORDER 3606
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SUBJECT TO AMENDMENT
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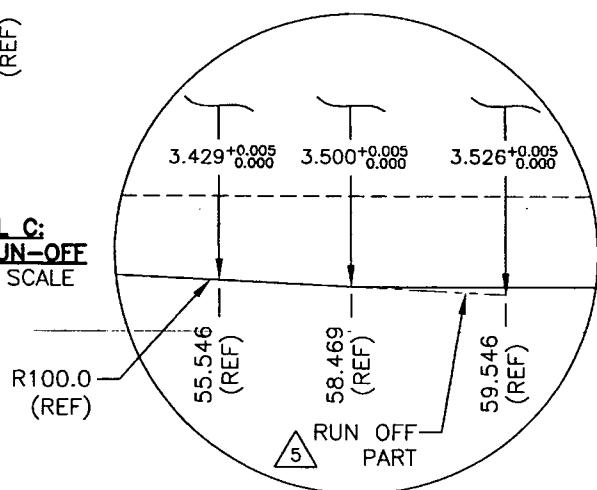
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CHECKED	97	APPROVED	JK	DRAWING NO.	REV. D
				D412-664-243	SHEET 2 OF 3
DATE	07.03.09	TITLE		CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:10

RELEASED
07-04-2449
PER ECN 889



**DETAIL B: CUFF
TRANSITION**
SCALE 4:1

**DETAIL C:
TAPER RUN-OFF**
NOT TO SCALE



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WORK ORDER
No. 36061

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DESIGN	DRAWN BY	DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA
PH	PH	REV. D
CHECKED	APPROVED	DRAWING NO.
		D412-664-243
DATE		SHEET 3 OF 3
07.03.09		SCALE
		1:1
		TITLE
		CROSSTUBE ASSEMBLY (412 HI AFT)



ACUREN

LIQUID PENETRANT TEST REPORT

P - 8-1206

CLIENT	DART AREOSPACE	DATE	JAN. 11, 2008	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	PAGE 1 OF 1		
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188-8-01206						
ADDRESS	1270 ABERDEEN ST. HAWKESBURY ONT.	PO/WO NO.							
		WORK LOCATION	HAWKESBURY						
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005				
PROJECT	HIGH AFT X-TUBE 412, 206B AFT X-TUBE, 206L FWD X-TUBE, 206L AFT X-TUBE								
ITEM(S) EXAMINED	JOBS #36061, 36062, 36371, 36372, 36374, 36375, 36376, 36378, 36380, 36382								
JOB DESCRIPTION		PROCEDURE NO.	LT-0002	REV./DATE	TECHNIQUE NO.			LT-0002-02	REV./DATE
Part No.	D206667201, D206667103, D412664203, D206667203			Material	ALODYNED ALUMINUM		Thickness		
Scope	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.								

TEST DETAILS

Method	<input checked="" type="checkbox"/> Fluorescent	<input type="checkbox"/> Visible	<input checked="" type="checkbox"/> Water Wash	<input type="checkbox"/> Solvent Removable	<input type="checkbox"/> Post Emulsified
Family Brand	MAGNAFLUX		Black Light S/N	8178	<input checked="" type="checkbox"/> Output > 1000 μ W/cm ²
Penetrant	ZL67	Minimum Dwell time	45	Min.	<input checked="" type="checkbox"/> Ambient < 2 fc
Penetrant Remover	H2O	Minimum Dry time	>10	Min.	<input checked="" type="checkbox"/> Output > 100 fc @ surface
Developer	SKDS2	Minimum Dwell time	10	Min.	Light Meter S/N
Developer Type	<input checked="" type="checkbox"/> Non Aqueous	<input type="checkbox"/> Aqueous	<input type="checkbox"/> Dry	Cal Due Date	MAR 08

TEST SURFACE

Surface Condition	<input checked="" type="checkbox"/> As Ground	<input type="checkbox"/> As Welded	<input checked="" type="checkbox"/> Machined	<input type="checkbox"/> Shot Blasted	<input type="checkbox"/> Clean Bare Metal
Surface Temperature	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F to 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- **METRIC** **IMPERIAL**

item	Comments	Accept	Reject					
Job #	36061: ACCEPTABLE							
	36062: ACCEPTABLE							
	36371: ACCEPTABLE							
	36372: ACCEPTABLE							
	36374: ACCEPTABLE							
	36375: ACCEPTABLE							
	36376: ACCEPTABLE							
	36378: ACCEPTABLE							
	36380: ACCEPTABLE							
	36382: ACCEPTABLE							

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

Client Representative	<u>C. Chagnon</u> print	<u>C. Chagnon</u> signature	DTR #
Technician (Signature):	<u>C. Chagnon</u>		Report Reviewed by:
Name (Print):	<u>FREDERICK CHAGNON</u>		Name initials
1 st technician CGSB Level <u>II</u> SNT Level <u> </u> CGSB Reg. No <u>10560</u>		2 nd technician CGSB Level <u> </u> SNT Level <u> </u> CGSB Reg. No <u> </u>	

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